

A-S-A-S

for back

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**Work Order ID 57145**

Tuesday, March 23, 2010 4:14:45 PM



Item ID: D3953-21

Accept



Setup Start



Revision ID:

Item Name: Gas Spring Bracket

Stop



Start Date: 3/24/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 3/29/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: MFDate: 10-3-23 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr Revision Nbr

D3953 C

100



Waterjet

FLOW CNC Waterjet

304 .125

Memo

0.00

1-Cut as per Dwg D3953

Dwg Rev: CProg Rev: E

2-Deburr if necessary

UR 10-3-30

03/10/03/30 (21)

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

UR 10-3-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 57145**

Tuesday, March 23, 2010 4:14:45 PM

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Item ID: D3953-21

Revision ID:

Item Name: Gas Spring Bracket

Start Date: 3/24/2010 Start Qty: 10.00

Accept



Setup Start



Required Date: 3/29/2010 Req'd Qty: 10.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

120



QC

Quality Control

Operation  
Description

QC8- Inspect parts - second check

Set Up/  
Run Hours

0.00

S 0602 | 30

Draw  
Number

Rev.

Plan  
Code

Code

Accept  
Qty

Qty

Reject  
Qty

Qty

Reject  
Number

Number

Insp.  
Stamp

130



Small Fab

Small Fab

Memo

1- CHAMFER HOLE AS PER DWG

2- DEBURR IF NECESSARY

0.00

0.00

*Customer*  
XZ2

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

S 0603 | 31

*Customer*  
XZ2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 57145**

Tuesday, March 23, 2010 4:14:45 PM



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Item ID: D3953-21

Revision ID:

Item Name: Gas Spring Bracket

Start Date: 3/24/2010 Start Qty: 10.00

Accept



Setup Start



Stop



Required Date: 3/29/2010 Req'd Qty: 10.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

150



Packaging

Packaging

Operation  
Description

Identify as per dwg &amp; Stock Location: ST102

Set Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

0.00

0.00

CY 10/3/31 22

160



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/04/06 HJ

MCO-A-5  
 22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Tuesday, March 23, 2010 4:14:44 PM

Page 1

Work Order ID: 57145



Parent Item: D3953-21



Parent Item Name: Gas Spring Bracket

Start Date: 3/24/2010

Required Date: 3/29/2010

Comments: IPP RevA: new issue DD 09.11.30 verified by:EC  
dwg revC DD 10.03.02 verified by:EC

IPP Rev:B as per

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No		100		sf	47.3194	0.1516	.5		IR10-3-30

304/316 0.125 Sheet

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
Main Warehouse		
MAT19	47.3194	
112663	47.3194	112663

(62)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

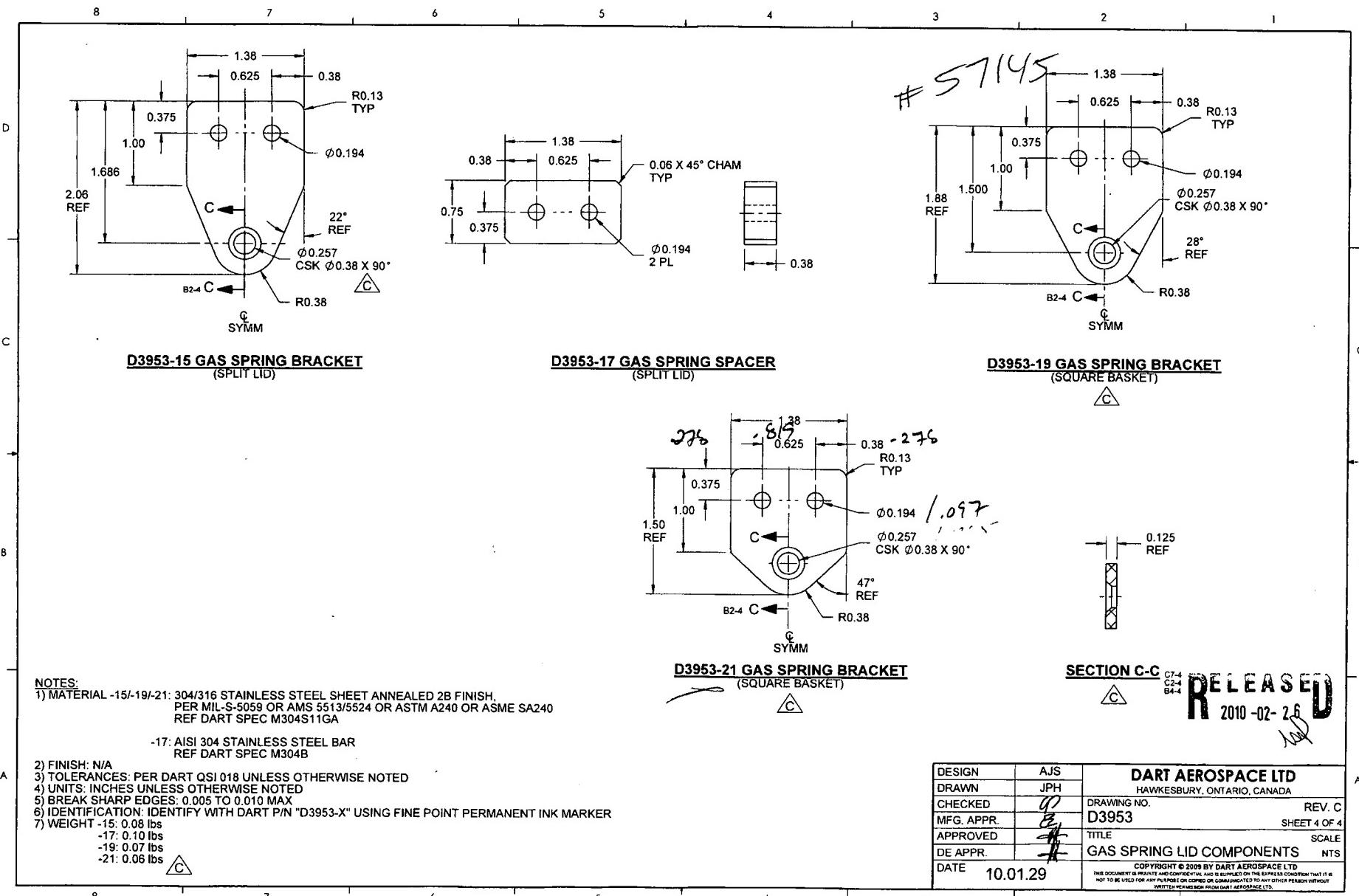
DART AEROSPACE LTD	Work Order:	57145
Description: GAS SPRING BRACKET	Part Number:	D3953-21
Inspection Dwg: D3953-21, Rev: C		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article X Prototype

Measured by:	HB	Audited by:	S	Prototype Approval:	
Date:	10-3-30	Date:	10/03/30	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries